

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000457**Date Inspected:** 14-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hou Jing Yao & Xu Bing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans Mock-Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M and 114M, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Skin Plate A (upper)	NA	NA	ZPMC MT/Caltrans MT
Mock-Up 114M, Skin Plate A (upper section): Caltrans QA Inspector witnessed ZPMC QC nondestructive (NDT) technician, Mr. Cai Xin Xin perform magnetic particle testing (MT) and Visual Testing (VT) inspection on the partial joint penetration weld root pass, weld number MUSC-MA106-1, MUSC-MA106-2, MUSC-MA106-4, MUSC-MA106-5, MUSC-MA106-7, MUSC-MA106-8, MUSC-MA106-10, MUSC-MA106-11, plate piecemark mp1002-2, 3, 4 and mp1001-1 to MA106-1. The MT coverage consisted of one-hundred percent of the root pass weld. MT test appeared to be in general conformance with AWS D1.5 2002 requirements. Caltrans QA Inspector performed MT at the locations, as mentioned above. See Caltrans Magnetic Particle Test Report, TL6028, generated on this date for additional information. The following digital pictures illustrate ZPMC MT in progress and Caltrans QA Inspectors inspection symbol, identifying the inspection of the weld.				

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Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
